

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-001430**Date Inspected:** 24-Jan-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1400**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wu Ming Kai**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Caltrans Quality Assurance Inspector Gabriel Quintana (QA Inspector) arrived at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China to observe fabrication and Quality Control Inspectors (QC Inspectors) perform their duties and responsibilities as specified in the contract documents, approved plans, fabrications documents and Special Provisions for this project. While on site the QA Inspector observed the following.

Bay 3- QA Inspector randomly observed ZPMC qualified welder Li Xuehua Identification (ID) #0058174 utilizing the Flux Core Arc Welding (FCAW) process per the approved Weld Procedure Specification (WPS) WPS-B-T-2132-2 while performing tack welding on Bottom Plate BP24 weld joints BP-024-01-019/020 to plate PL52A. QA Inspector observed ZPMC Quality Control Certified Weld Inspector (QC Inspector) Wu Ming Kai monitoring welding and preheating parameters. The QA Inspector also randomly monitored weld parameters and recorded them as follows: welding amperage 275 amps, welding voltage 28 volts. The weld parameters appeared to comply with contract requirements and the approved WPS.

Bay 3- QA Inspector randomly observed ZPMC qualified welder Wang Zhonghua ID #053753 utilizing the Shielded Metal Arc (SMAW) process per the approved procedure WPS-B-T-2112 while performing tack welding on Side Plate SP42 weld joints SP042-01-015/016 to plate PL90B QA Inspector observed QC Inspector Wu Ming Kai monitoring welding and preheating parameters. The QA Inspector also randomly monitored weld parameters used and recorded them as the following using 4.0mm diameter electrode: amperage 165 amps, welding voltage 22.5 volts. The weld parameters appeared to comply with contract requirements and the approved WPS.

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Bay 3- QA Inspector randomly observed ZPMC qualified welder He Yumei Identification (ID) #048625 utilizing the FCAW process per the approved procedure WPS-B-T-2132-2 while performing tack welding on Bottom Plate BP19 weld joints BP019-01-021/022 to plate PL48A. QA Inspector observed ZPMC QC Inspector Wu Ming Kai monitoring welding and preheating parameters. The QA Inspector also randomly monitored weld parameters and recorded them as follows: welding amperage 280 amps, welding voltage 28 volts. The weld parameters appeared to comply with contract requirements and the approved WPS.



Summary of Conversations:

General communications took place between the QA and QC Inspector.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Quintana, Gabriel
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Quality Assurance Inspector

Reviewed By:	Cochran, Jim
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QA Reviewer
